

Work Order ID 83889***83889***

Page 1

Thursday, April 26, 2012 3:21:58 PM

Item ID: D4419-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Support Plate
Start Date: 4/26/2012 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 5/10/2012 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: *MNK* Date: *12-04-26* Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4419	A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

16 *0* *Jm/22*
12-4-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16 *0* *Jm/22*
12-4-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83889

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Page 2

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120 QC8- Inspect parts - second check 0.00

120

QC

Memo

0.00

5/26/12

16

Quality Control

130 Identify as per dwg & Stock Location: 85135H 0.00

130

Packaging

Memo

0.00

16x

8p

Packaging

12-05-02

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

12/5/12

Quality Control

MF

12-05-01

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Picklist Print

Thursday, April 26, 2012 3:21:57 PM

Page 1

Work Order ID: 83889
Parent Item: D4419-1
Parent Item Name: Fwd Support Plate

Start Date: 4/26/2012
Start Qty: 16.00
Required Date: 5/10/2012
Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No				sf	45.9900		5.8206316			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	45.99	
121070	3.69	
121380	42.3	

121380
[5.9]

5m/5m
12-4-28

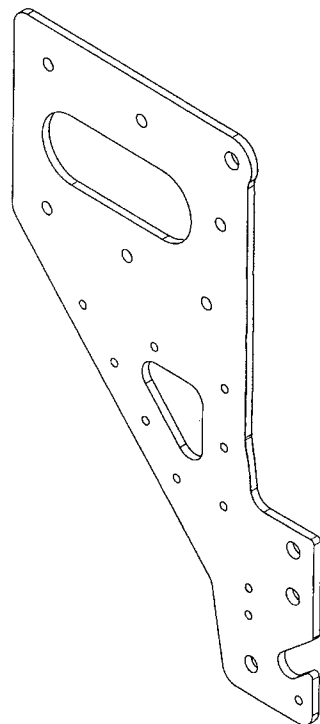
W/O:		WORK ORDER CHANGES					
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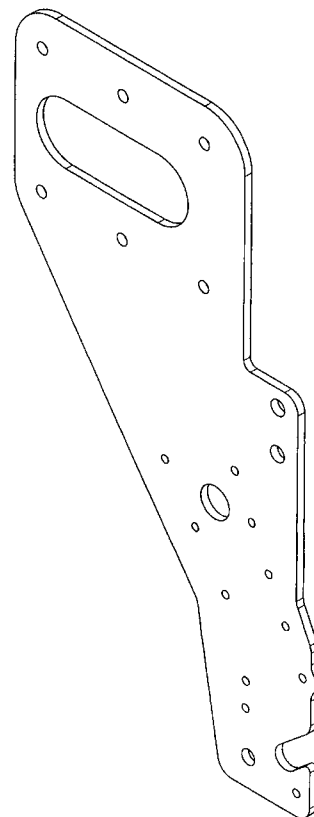
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NOTE: Date & initial all entries



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

4 83889

RELEASED
2011-07-28
JW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

A		NEW ISSUE		AJS	11.07.06
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 3	
CHECKED	92	DRAWING NO.		SCALE	
MFG. APPR.	E	D4419		NTS	
APPROVED	10	TITLE		SCALE	
DE APPR.	10	BASKET SUPPORT PLATES		NTS	
DATE	11.07.06	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

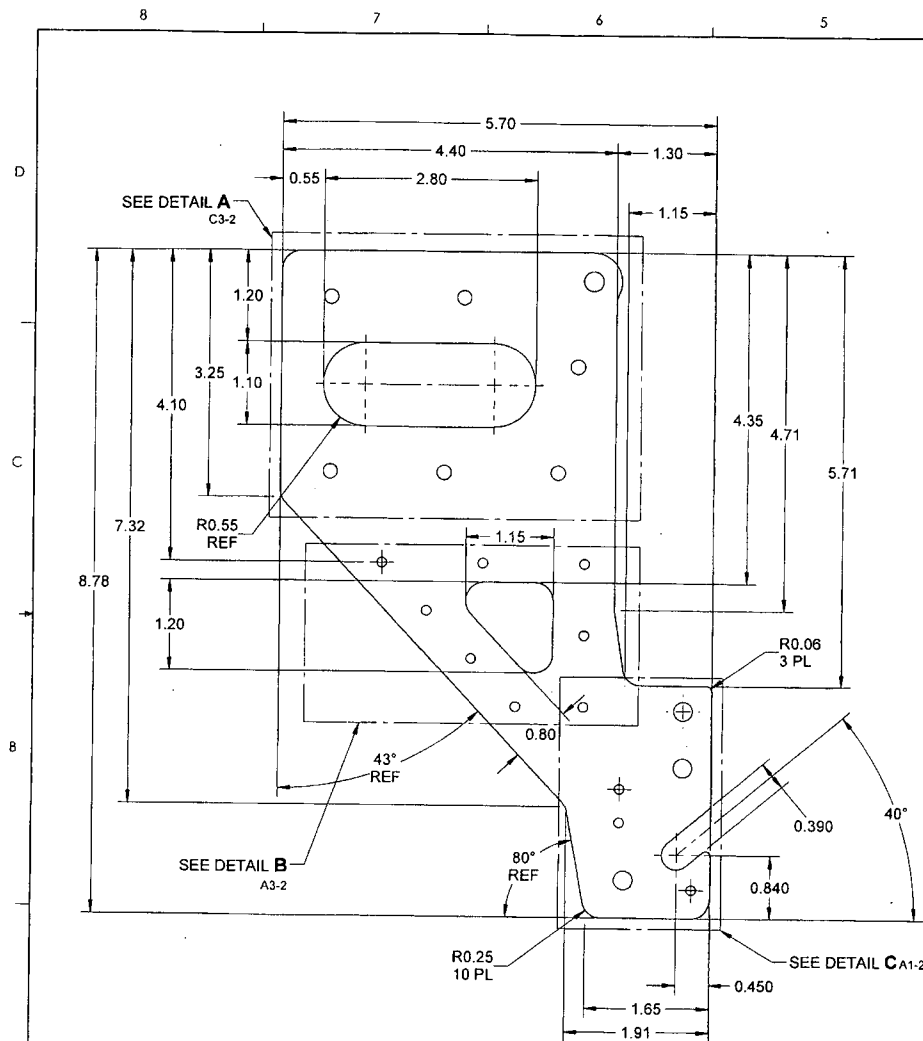
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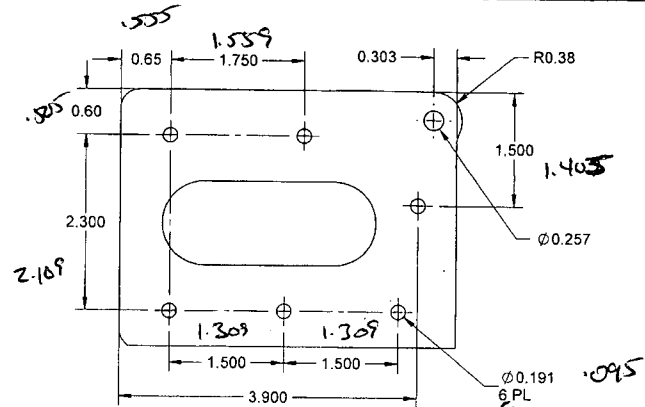
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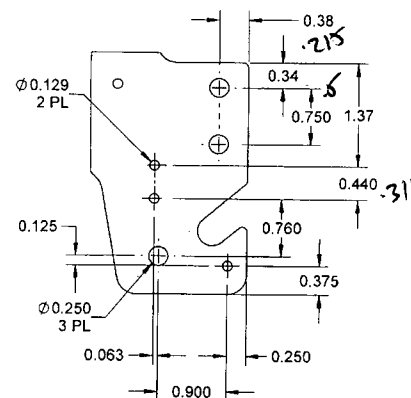
NOTE: Date & initial all entries



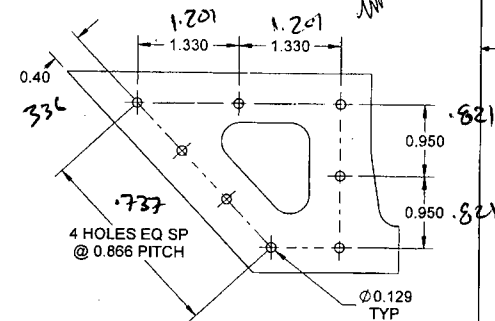
D4419-1 FWD SUPPORT PLATE



DETAIL A D8-2



DETAIL B B7-2



DETAIL C A4-2

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4419	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET SUPPORT PLATES	NTS
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2011-07-28

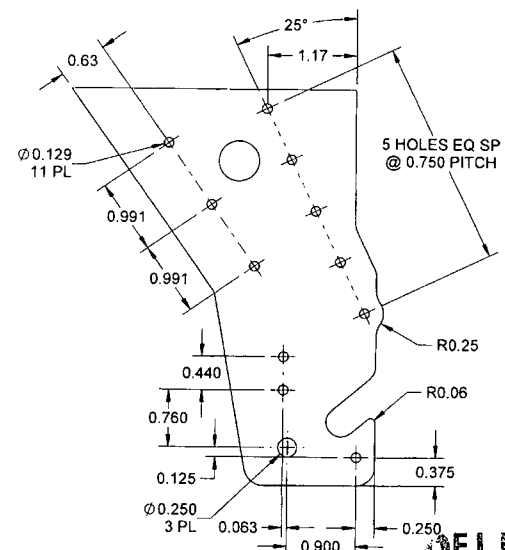
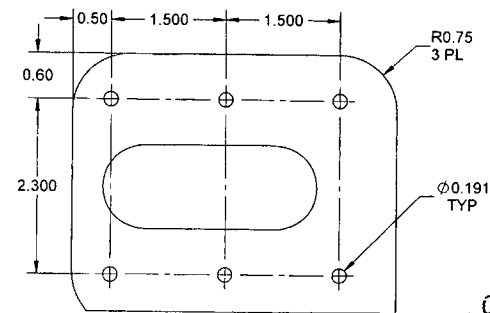
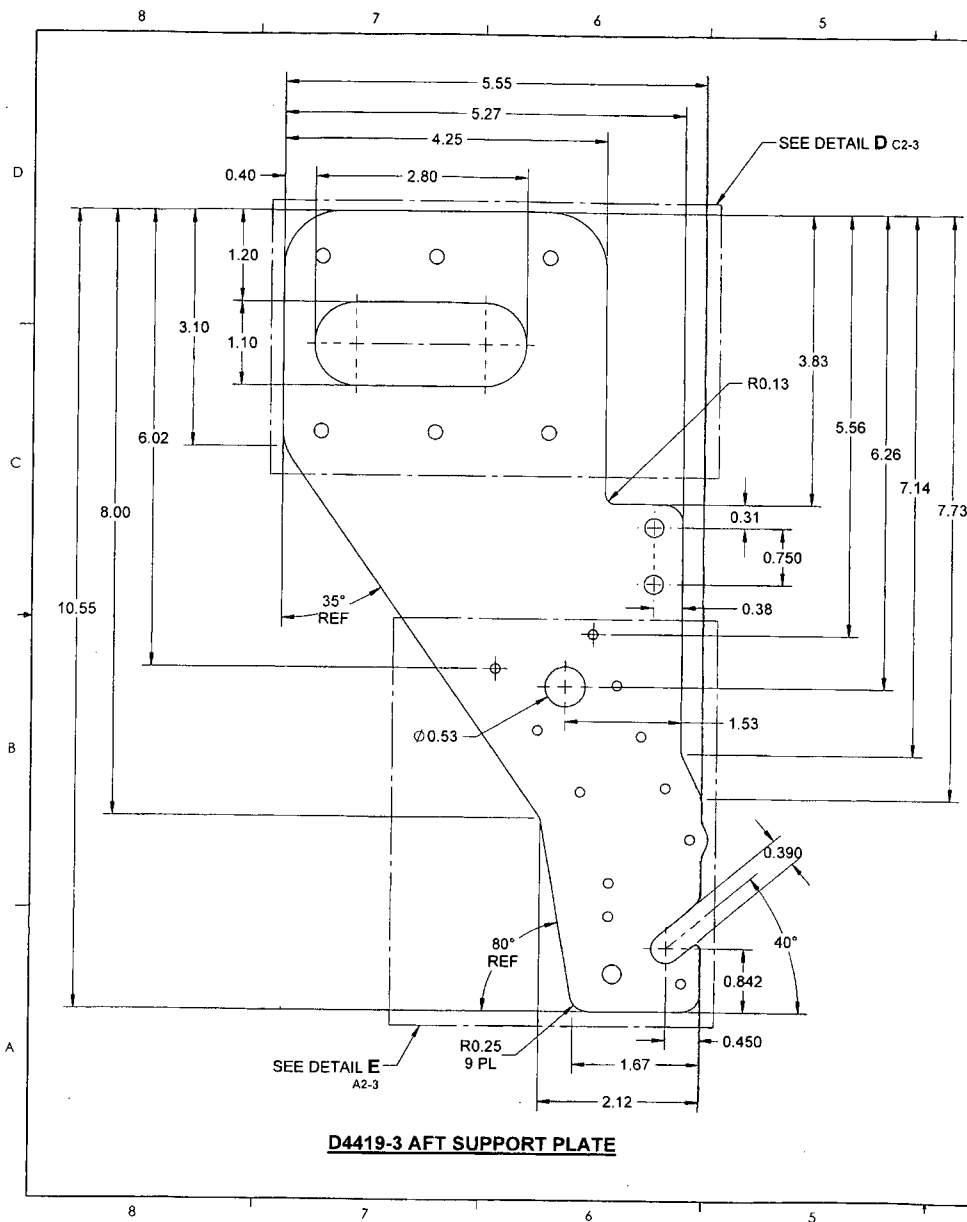
Dart Aerospace Ltd

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4419	SHEET 3 OF 3
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DE APPR.	<i>[Signature]</i>	BASKET SUPPORT PLATES	NTS
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#53589

RELEASED
2011-11-28

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DART AEROSPACE LTD		Work Order: 8389
Description: Fwd Support Plate		Part Number: D4419-1
Inspection Dwg: D4419	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		vern	HB-02
Ø0.191	+0.005/-0.001	0.191	✓		vern	HB-02
Ø0.250	+0.005/-0.001	0.249	✓		vern	HB-02
Ø0.257	+0.006/-0.001	0.257	✓		vern	HB-02
5.70	+/-0.030	5.714	✓		vern	HB-02
4.40	+/-0.030	4.414	✓		vern	HB-02
0.55	+/-0.030	0.55	✓		RG	
2.80	+/-0.030	2.800	✓		vern	HB-02
1.30	+/-0.030	1.307	✓		vern	HB-02
4.35	+/-0.030	5.716	✓		vern	HB-02
5.71	+/-0.030	5.716	✓		vern	HB-02
0.450	+/-0.010	0.453	✓		vern	HB-02
0.80	+/-0.030	0.813	✓		vern	HB-02
1.20	+/-0.030	1.212	✓		vern	HB-02
1.10	+/-0.030	1.093	✓		vern	HB-02
3.25	+/-0.030	3.249	✓		vern	HB-02
4.10	+/-0.030	4.108	✓		vern	HB-02
1.20	+/-0.030	1.203	✓		vern	HB-02
7.32	+/-0.030	7.330	✓		vern	HB-02
8.78	+/-0.030	8.791	✓		vern	HB-02
0.65	+/-0.030	0.651	✓		vern	HB-02
0.60	+/-0.030	0.608	✓		vern	HB-02
1.750	+/-0.010	1.749	✓		vern	HB-02
0.303	+/-0.010	0.306	✓		vern	HB-02
1.500	+/-0.010	1.503	✓		vern	HB-02
2.300	+/-0.010	2.301	✓		vern	HB-02
3.900	+/-0.010	3.906	✓		vern	HB-02
0.34	+/-0.030	0.340	✓		vern	HB-02
0.750	+/-0.010	0.752	✓		vern	HB-02
1.37	+/-0.030	1.359	✓		vern	HB-02
0.440	+/-0.010	0.435	✓		vern	HB-02
0.760	+/-0.010	0.760	✓		vern	HB-02
0.375	+/-0.010	0.370	✓		vern	HB-02

S, 2/04/20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83889
Description: Fwd Support Plate		Part Number:	D4419-1
Inspection Dwg: D4419	Rev: A	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.247	✓		vern	HB-02
0.900	+/-0.010	0.902	✓		vern	HB-02
0.063	+/-0.010	0.063	✓		vern	HB-02
0.125	+/-0.010	0.126	✓		vern	HB-02
1.330	+/-0.010	1.330	✓		vern	HB-02
0.950	+/-0.010	0.952	✓		vern	HB-02
0.866	+/-0.010	0.866	✓		vern	HB-02
0.40	+/-0.030	0.406	✓		vern	HB-02
0.125	+/-0.010	0.119	✓		vern	HB-02

Measured by:	Jm/px	Audited by:	S	Preliminary Approval:	
Date:	12-4-28	Date:	12/4/30	Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	

Dart Aerospace Ltd

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